

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019726**Date Inspected:** 06-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 14W:

Repair welding of weld joint no: SEG 3020X-013 [Longitudinal Diaphragm (LD) to Bottom Panel (BP), complete joint penetration (CJP) weld at panel point (PP) 126]. The welder is identified as 045175 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC Quality Control (QC) was identified as Zhu Lin. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): B-CWR 2662 Rev-0.

Repair welding of weld joint no: SEG 3020AA-025 (LD to BP, CJP weld at PP127.3). The welder is identified as 067942 and was observed welding in the 2G position. Welding process was identified as Shielded Metal Arc Welding (SMAW). ZPMC QC was identified as Zhu Lin. The welding variables recorded by this QC appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per CWR: B-CWR 2658 Rev-0.

OBG Seg 13AW:

Repair welding of weld joint no: SEG3013K-003 [Floor Beam (FB) 3184K to BP, CJP weld, at PP119-1500]. The welder is identified as 045280 and was observed welding in the 2G position. Welding process was identified as Flux Cored Arc Welding (FCAW). ZPMC QC was identified as Li Ping. The welding variables recorded by this QC appeared to comply with WPS: 345-FCAW-2G(2F)-FCM-Repair-ESAB. Repair welding was done as per Welding Repair Report (WRR): B-WR 19197 Rev-0.

Repair welding of weld joint no: SEG 3013F-003 (FB3191A to BP, CJP weld, at PP119+1500). The welder is identified as 045221 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Li Ping. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per WRR: B-WR 19195 Rev-0.

For FCAW, this QA Inspector verified that the voltage and the amperage were maintained as per WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

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| Inspected By: | Wadkar,Sailesh | Quality Assurance Inspector |
| Reviewed By: | Patterson,Rodney | QA Reviewer |
